

6061 t6 3"

Work Order ID 163393***163393***

Page 1

Item ID: D5149-1TRN

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Step Base Turning Detail

Start Date: 7/17/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/21/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

DAS

Date:

JUL 03 2017

Tooling:

Date:

Run Start ***NR1***

QC:

21

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5149	D

100

0.51

100

Doosan

Doosan Lathe

MORI SEIKI CNC LATHE LARGE

Memo

1.81

Turn blank as per Folio FB355

4

DAS

39

9-89

2017-07-10

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.04

4

DAS

39

9-89

2017-07-10

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.08

4

0

DAS

45

9-89

2017-07-10

Work Order ID 163393

Tuesday, June 27, 2017 11:36:48 AM

163393

Page 2

Item ID: D5149-1TRN**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Fwd Step Base Turning Detail**Stop *NS2*****Start Date:** 7/17/2017 **Start Qty:** 4.00***4*****Cust Item ID:****Required Date:** 7/21/2017 **Req'd Qty:** 4.00***4*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				4	0		DAS 45 9-80 2017-7-10
130 Packaging	Memo LOCATION: MAT060	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							17/7/12
140 QC	Memo	0.40							
Quality Control									



JUL 11 2017

Picklist Print

Tuesday, June 27, 2017 11:36:47 AM

Work Order ID: 163393

163393

Parent Item: D5149-1TRN

D5149-1TRN

Parent Item Name: Fwd Step Base Turning Detail

Start Date: 7/17/2017

Required Date: 7/21/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 14-12-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R3.000		Purchased	No			100	f	9.4700	0.416	1.751579		39 9-99	
									**		1.708	2017-07-10	
M6061T6R3 000													
6061-T6 RD BAR 3.000"													

Location

Loc Qty

Loc Code

MAT012

9.47

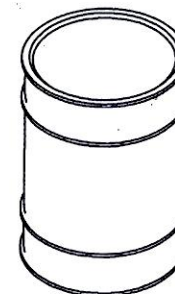
m133699

0.4

m135689

9.07

1.708



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 163396ms
17070h

1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM
REF DART SPEC. M6061T6R

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.41 lbs

RELEASED
2015-11-04

APPROVED

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	DD	D5149	SHEET 8 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY	NT
DATE	15.10.20	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED BY THE EXEMPTOR COMPANY. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION BY DART AEROSPACE LTD.	

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